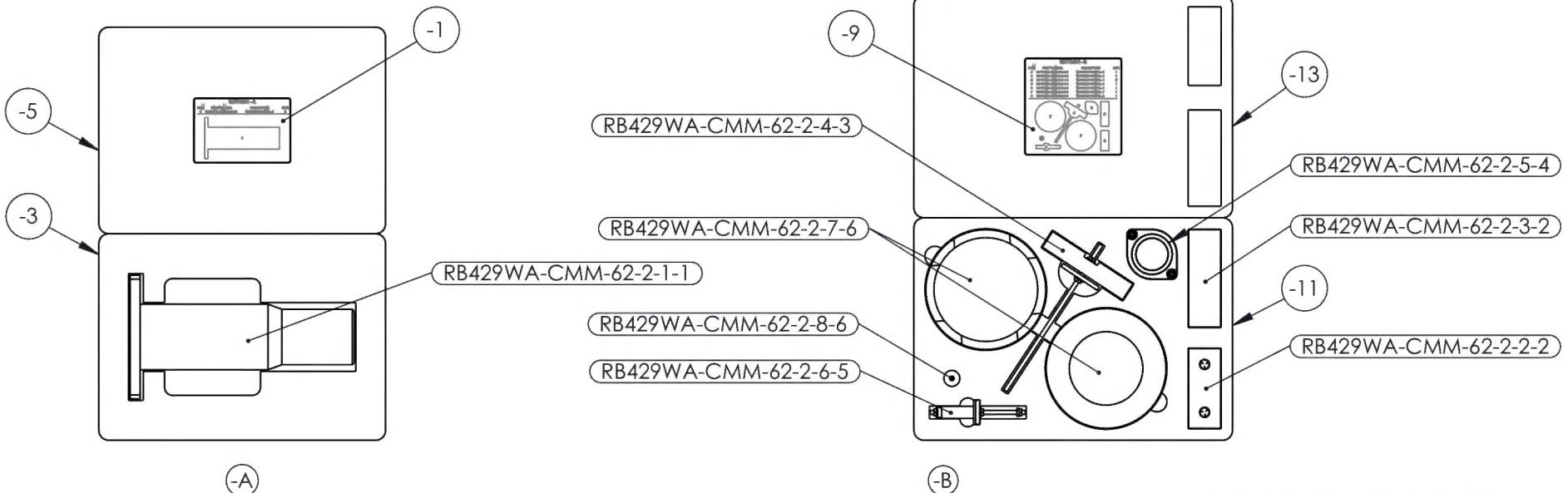


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.			9/26/2016	DPD	JAG
2	17-0042	ADDED NOTES 2 & 3. -A, -B ADDED. -1 REMOVED WORKAID ITEM No. 2 THRU 8 FROM PLACARD, CH'D DIM WAS 7.00 IS 4.00. -3 MODIFIED TO CONTAIN ONLY WORKAID ITEM No. 1; REPLACED TO FIT PELICAN IM2450 CASE. -5 REPLACED TO FIT PELICAN IM2450 CASE. -7 CH'D B/O INFO WAS PELICAN #APP-1610-E IS PELICAN #APP-IM2450-E. -9, -11, -13, -15 ADDED.			2/21/2017	SM	JAG



SEE ATTACHED DEVIATION

NOTES:

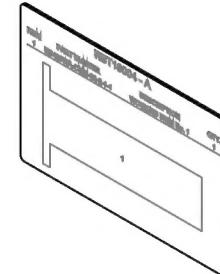
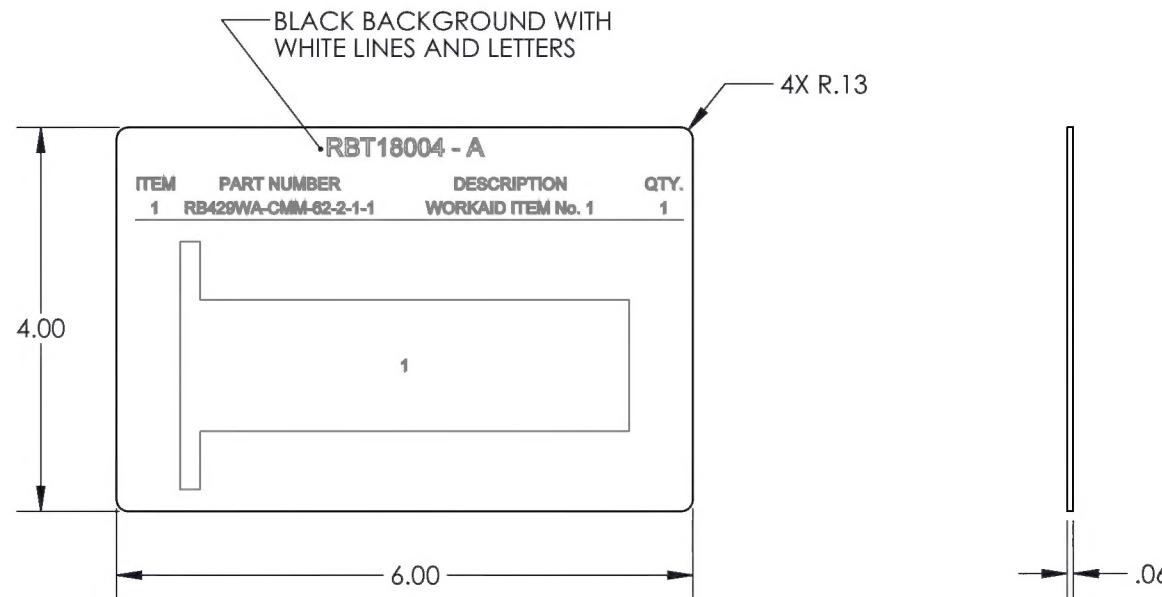
1. REFERENCE FIGURE 62-2.
2. ENGRAVE RBT18004-A ON PLACARD USED IN ASSEMBLY A.
3. ENGRAVE RBT18004-B ON PLACARD USED IN ASSEMBLY B.



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-A	1	ASSEMBLY A			1
X			-B	1	ASSEMBLY B			1
1			RB429WA-CMM-62-2-1-1		WORKAID ITEM No. 1			1
1			RB429WA-CMM-62-2-2-2		WORKAID ITEM No. 2			1
1			RB429WA-CMM-62-2-3-2		WORKAID ITEM No. 3			1
1			RB429WA-CMM-62-2-4-3		WORKAID ITEM No. 4			1
1			RB429WA-CMM-62-2-5-4		WORKAID ITEM No. 5			1
1			RB429WA-CMM-62-2-6-5		WORKAID ITEM No. 6			1
1			RB429WA-CMM-62-2-7-6		WORKAID ITEM No. 7			1
1			RB429WA-CMM-62-2-8-6		WORKAID ITEM No. 8			1
1		-1	ASSEMBLY A CONTENTS PLACARD		PLASTIC			2
1	B/O	-3	ASSEMBLY A BOTTOM FOAM	ETHAFOAM 220, BLACK	6.40 X 13 X 18 (CASE SOLUTIONS)			3
1	B/O	-5	ASSEMBLY A TOP FOAM	ETHAFOAM 220, BLACK	1.87 X 13 X 18 (CASE SOLUTIONS)			4
1	B/O	-7	ASSEMBLY A CASE	PLASTIC	PELICAN #APP-IM2450-E		N/S	
1		-9	ASSEMBLY B CONTENTS PLACARD	PLASTIC				5
1	B/O	-11	ASSEMBLY B BOTTOM FOAM	ETHAFOAM 220, BLACK	19.88 X 13.88 X 7.88 (CASE SOLUTIONS)			6
1	B/O	-13	ASSEMBLY B TOP FOAM	ETHAFOAM 220, BLACK	19.88 X 13.88 X 1.78 (CASE SOLUTIONS)			7
1	B/O	-15	ASSEMBLY B CASE	PLASTIC	PELICAN #APP-IM2620-E		N/S	
1	1	B/O	PLACARD	ALUMINUM	RB41011		N/S	
ASSY -B	ASSY -A							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0042	-1 REMOVED WORKAID ITEM No. 2 THRU 8 FROM PLACARD, CH'D DIM WAS 7.00 IS 4.00.	2/21/2017	SM	JAG



NOTE:
USE PDF.

SEE ATTACHED DEVIATION

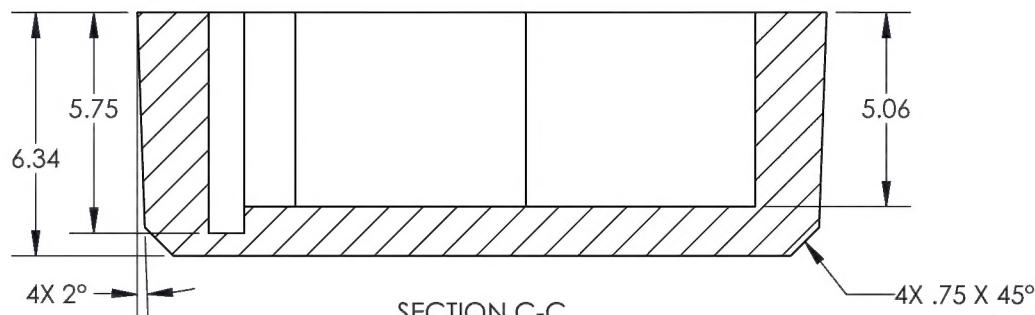
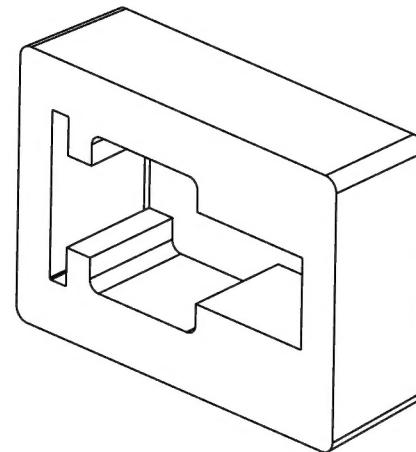
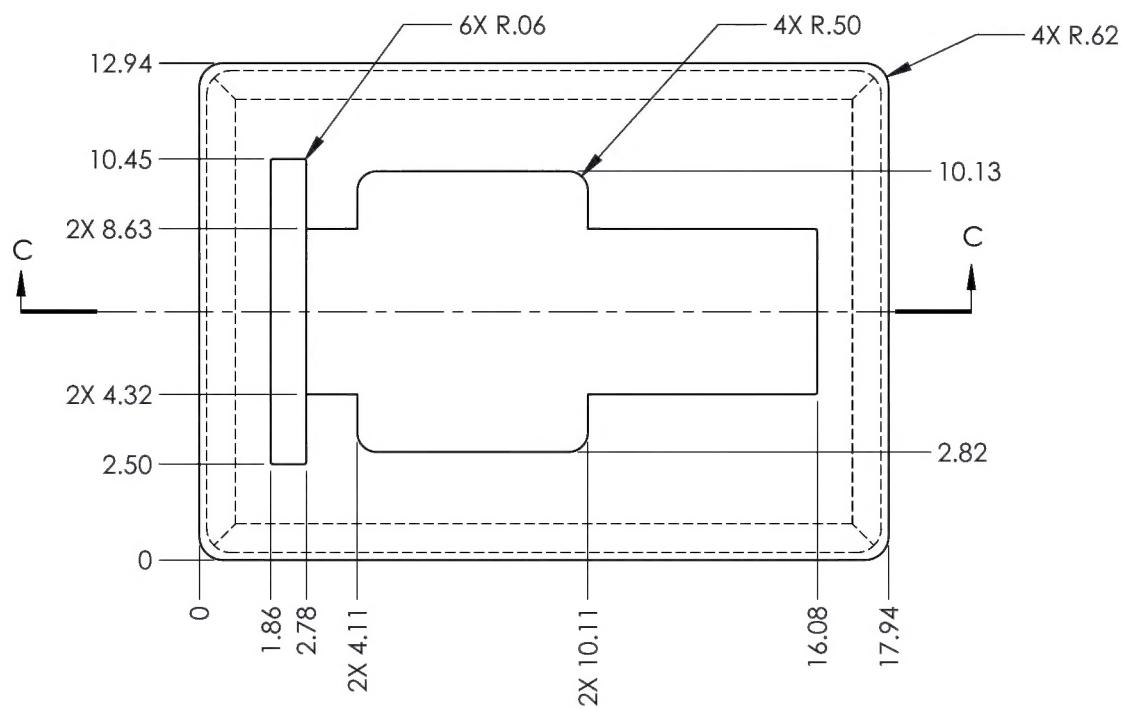
DART AEROSPACE	
TITLE MAIN ROTOR HUB ASSEMBLY - WORKAID ITEMS No. 1 THROUGH No. 8	
DWG NO.	RBT18004-1
REV	2
MATERIAL PLASTIC UNLESS OTHERWISE SPECIFIED HEAT XXX ± .010 FRACTIONS ± 1/8 TREAT XX ± .03 ANGLES ± 1° FINISH X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY: DUERFELDT CHECKED: MACKOVJAK OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL BELL 429	
SCALE 1:2	DATE 9/15/2016
SHEET 2 OF 7	

(-1)

ASSEMBLY A CONTENTS PLACARD

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REVIEWS			DESCRIPTION			DATE	INITIAL	APPROVED
REV	ECR							
2	17-0042	-3	MODIFIED TO CONTAIN ONLY WORKAID ITEM No. 1; REPLACED TO FIT PELICAN iM2450 CASE.			2/21/2017	SM	JAG



(-3)

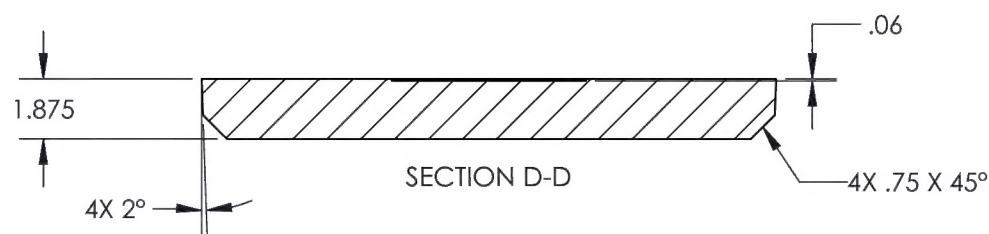
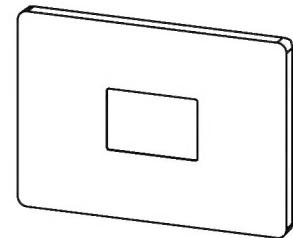
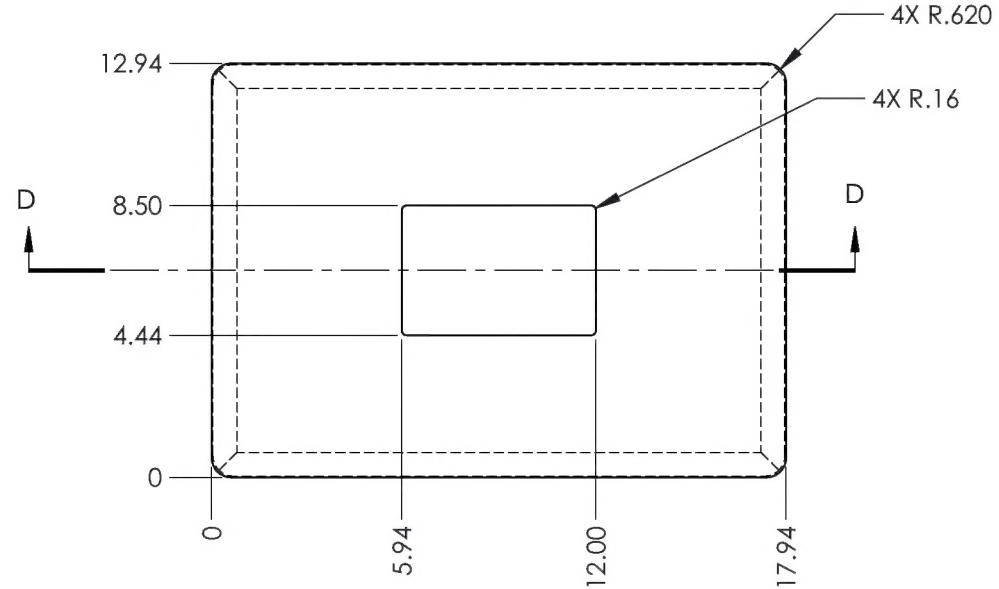
ASSEMBLY A BOTTOM FOAM

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MAIN ROTOR HUB ASSEMBLY - WORKAID ITEMS No. 1 THROUGH No. 8	
DWG NO. RBT18004-3 REV 2	
MATERIAL ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	DUERFELDT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	BELL 429
SCALE 1:5	DATE 9/15/2016
SHEET 3 OF 7	

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REV			ECR			DESCRIPTION			REVISIONS		
1	17-0042	-5	REPLACED TO FIT PELICAN iM2450 CASE.			DATE	INITIAL	APPROVED	2/21/2017	SM	JAG



ASSEMBLY A TOP FOAM

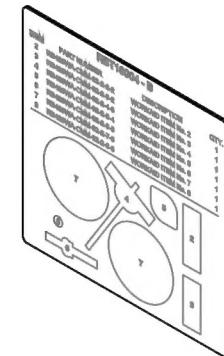
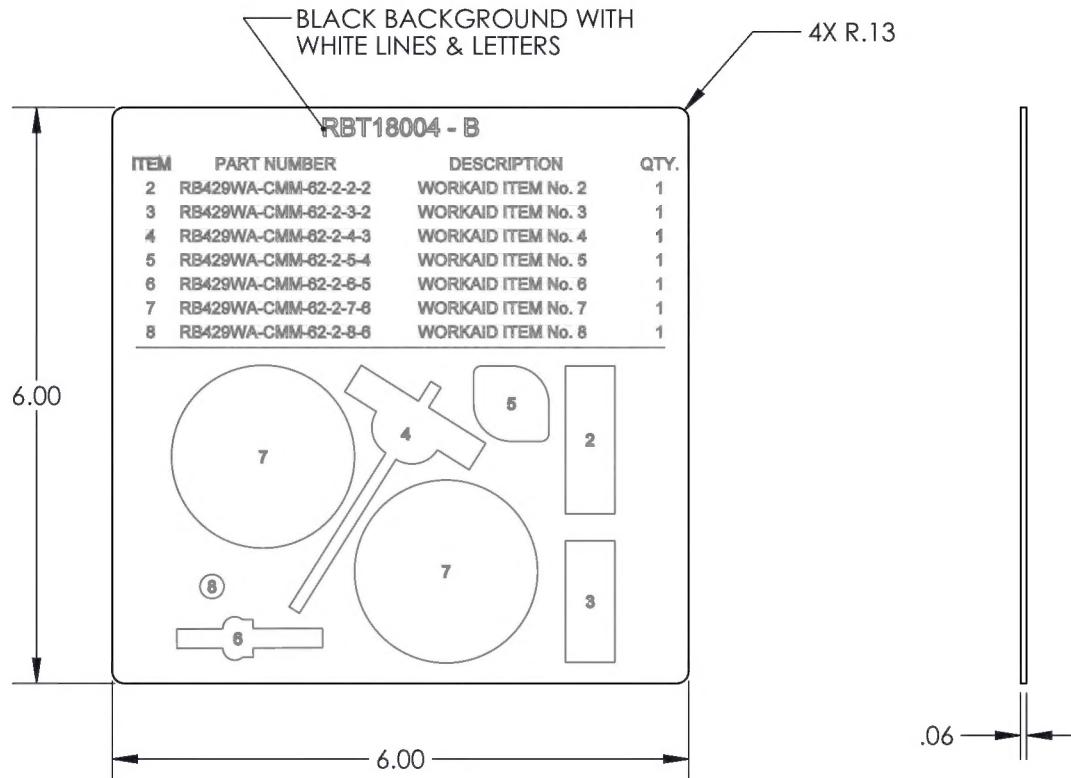
(5)

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MAIN ROTOR HUB ASSEMBLY -	
WORKAID No. 1 THROUGH No. 8	
DWG NO. RBT18004-5 REV 2	
MATERIAL ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY: DUERFELDT	
CHECKED: MACKOVJAK	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY USED ON MODEL	
APPROVED: GILBERT BELL 429	
SCALE 1:6	DATE 9/15/2016
SHEET 4 OF 7	

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REV			ECR			DESCRIPTION			REVISIONS		
DATE	INITIAL	APPROVED									
2/21/2017	SM	JAG									



NOTE:
USE PDF.

SEE ATTACHED DEVIATION

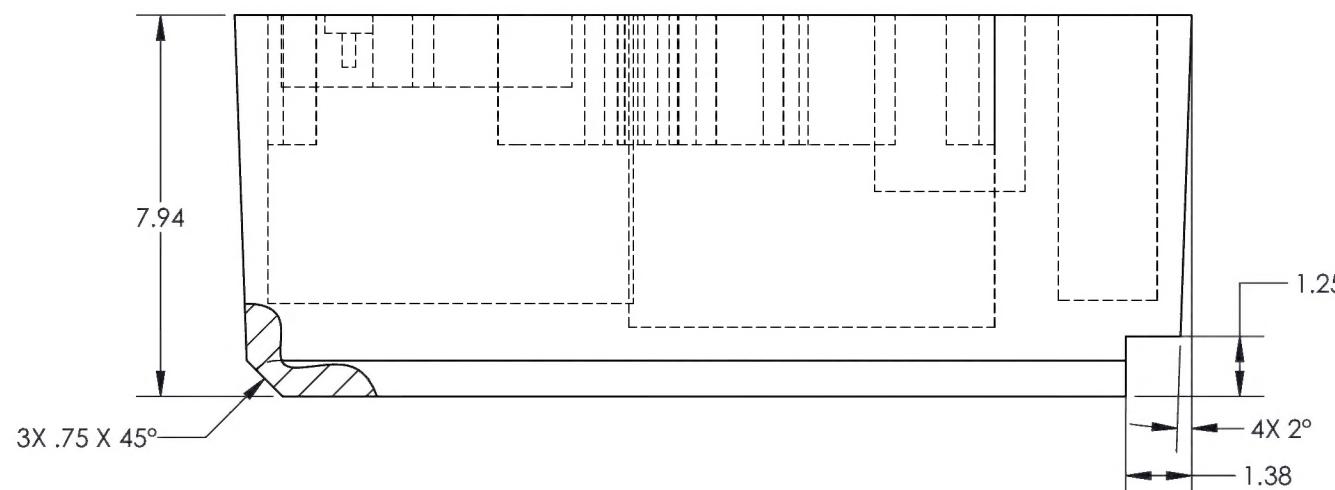
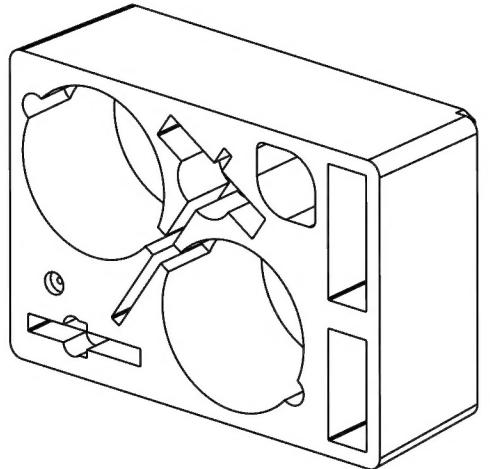
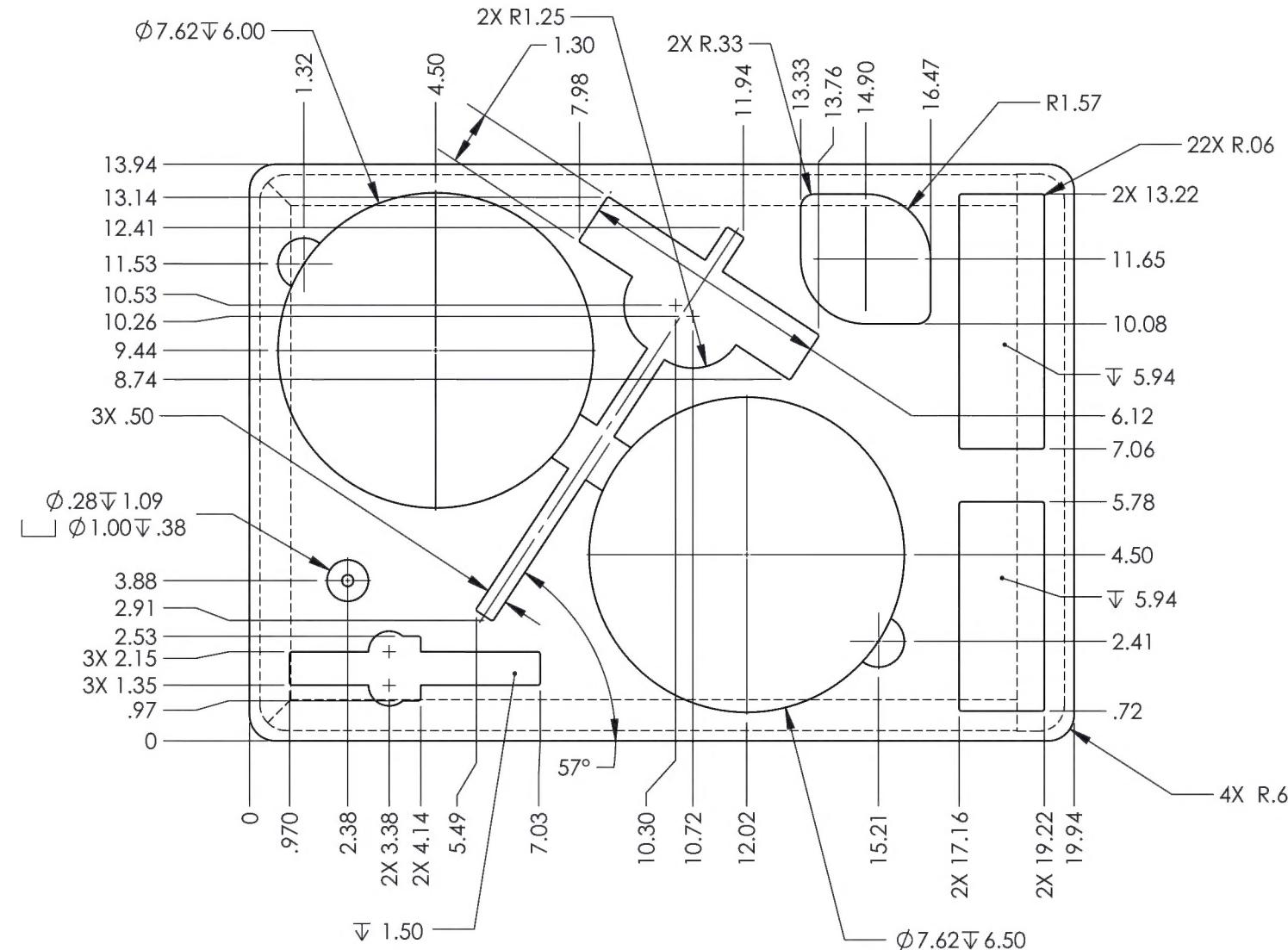
DART AEROSPACE	
TITLE MAIN ROTOR HUB ASSEMBLY - WORKAID ITEMS No. 1 THROUGH No. 8	
DWG NO.	RBT18004-9
REV	2
MATERIAL PLASTIC	
HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY: DUERFELDT	
CHECKED: MACKOVJAK	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE	1:2
DATE	9/15/2016
SHEET 5 OF 7	

(-9)

ASSEMBLY B CONTENTS PLACARD

REVISONS		
REV	ECR	DESCRIPTION
2	17-0042	-11 ADDED FOR WORKAID ITEMS 2-8.

DATE INITIAL APPROVED
2/21/2017 SM JAG



(-11)

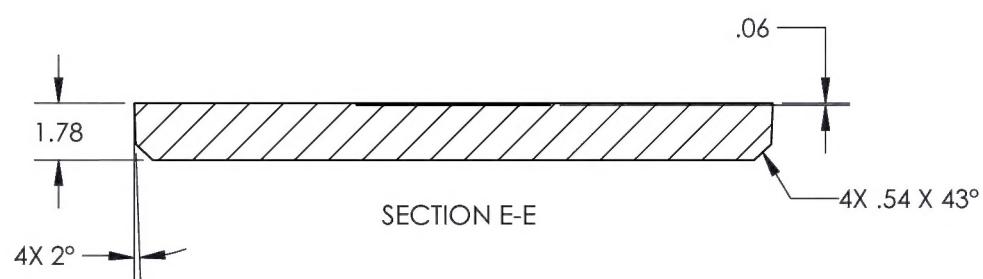
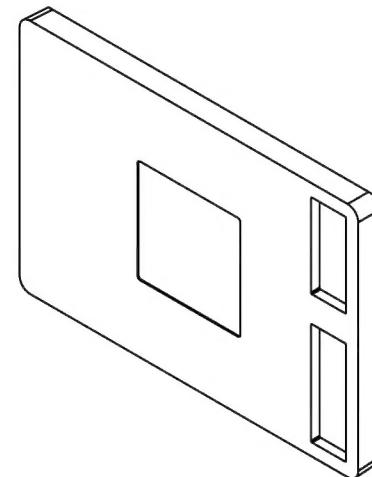
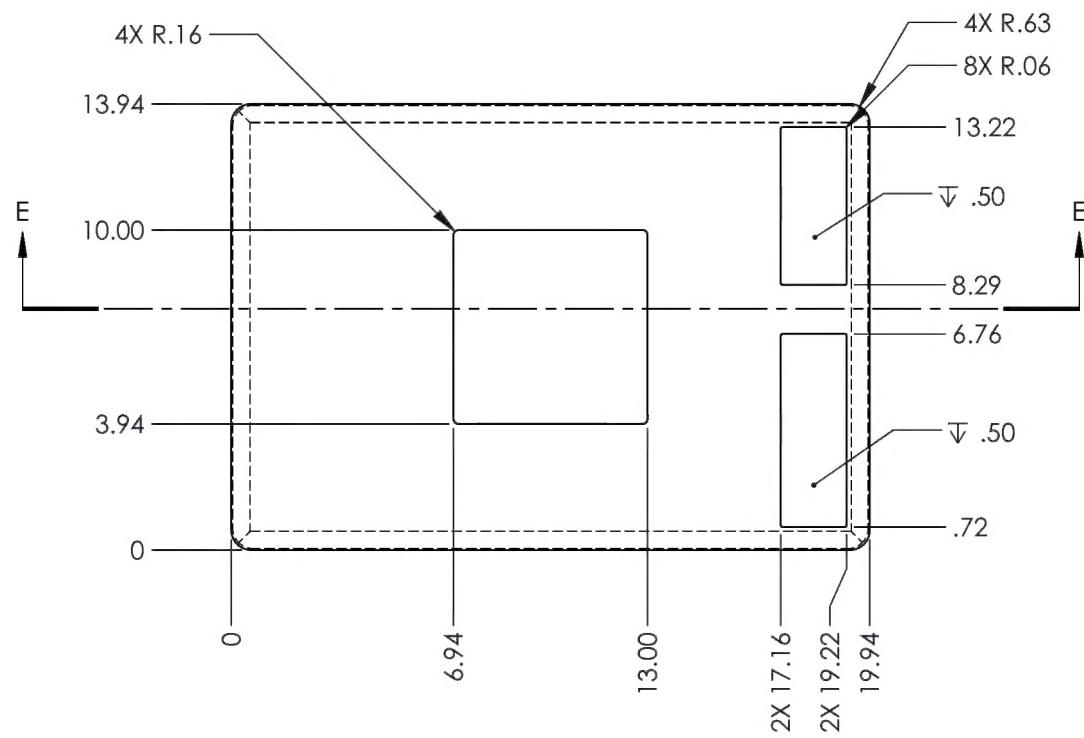
ASSEMBLY B BOTTOM FOAM

SEE ATTACHED DEVIATION

DART AEROSPACE		
TITLE MAIN ROTOR HUB ASSEMBLY - WORKAID ITEMS No. 1 THROUGH No. 8		
DWG NO.	RBT18004-11	
REV	2	
MATL	ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
HEAT	.XXX ± .010 FRACTIONS ± 1/8	
TREAT	.XX ± .03 ANGLES ± 1°	
FINISH	X ± .1 SURFACES = 125	
SPEC	1. BREAK ALL SHARP EDGES ✓	
DRAWN BY:	DUERFELDT	
CHECKED:	MACKOVJAK	
OPPS APPR:	ANDERSON	
QA APPR:	LINDSAY	
APPROVED:	GILBERT	
USED ON MODEL	BELL 429	
SCALE	1:4	
DATE	9/15/2016	
SHEET	6 OF 7	

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REV			ECR			DESCRIPTION			REVISIONS		
2	17-0042	-13 ADDED FOR WORKAID ITEMS 2-8.							DATE	INITIAL	APPROVED
									2/21/2017	SM	JAG



SECTION E-E

ASSEMBLY B TOP FOAM

(-13)

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MAIN ROTOR HUB ASSEMBLY - WORKAID ITEMS No. 1 THROUGH No. 8	
DWG NO. RBT18004-13 REV 2	
MATEL ETHAFOAM 220, BLACK UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT FRACTIONS $\pm \frac{1}{16}$ FINISH ANGLES $\pm 1^\circ$.XX $\pm .03$ X $\pm .1$ SURFACES = 125 SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	DUERFELDT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:6
DATE	9/15/2016
SHEET 7 OF 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____	DISPOSITION	DEPARTMENT/PROCESS					
Part No. RBT18004 Rev. 2	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is	<input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab	<input type="checkbox"/> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing	<input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging	<input type="checkbox"/> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality	X Engineering Water Jet Supplier Quality	
Date : _____	Sequence #: _____	QTY Affected : _____				MRB (QSI042) Oct 25, 2018	
Description Work Order Deviation	Disposition						
Replace 2 bolts installed on tool (RBT18004) RB429WA-CMM-62-2-2-2 with McMaster Carr 92620A702	<p>This deviation is acceptable.</p> <p>The fit, form and function of the part will be as originally intended.</p>						
Completed By Lead hand / Supervisor QC / QA Coordinator							
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Preservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>	FAULT CATEGORY Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled <input type="checkbox"/> Other/Details: _____						
	Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread <input type="checkbox"/>				